

Date: Monday, 1/28/2008 12:01:05 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP WELDMENT		
Job Number	37029			Part Number	D3562042		
Estimate Number	12577			Drawing Number	D3562 UNDER REVIEW		
P.O. Number				Project Number	N/A		
This Issue	1/28/2008	S.O. No.		Drawing Revision	D		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	2/6/2008	Qty:	1
Previous Run	36499			Um:	Each		
Written By	<u>KJ</u> 08.01.28						
Checked & Approved By							
Comment	Est Rev:A	New Issue	06-11-09 JLM				
	Est rev B	ECN 987	07.10.09 EC	verified by: DD			
	Est Rev:C	ECN1048	07-12-18 DD	verified by: EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>B35618</u>		
Check Material for any Dents or Defects SAD 08:01:29		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding SAD 08:01:29		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP SAD 08:01:29		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 SAD 08:01:29		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/28/2008 12:01:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 37029

Part Number: D3562042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 D3560042 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch: 335030

PL 08.01.28

7.0 D3560044 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch: 335298

PL 08.01.29

8.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Blind Rivet

batch: m106375

PL 08.01.28

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(Pb)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Magnabond 6398 Batch: m104677

PL 08.01.28

PL 08.01.29

PL 08.01.29

10.0 QC5 INSPECT WORK TO CURRENT STEP



06/01/30

Comment: INSPECT WORK TO CURRENT STEP

11.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap B34485

PL 08.01.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: N/A Fault Category: Prod (Manufacturing) NCR: Yes No DQA: A Date: 2023/01/29
 QA: N/C Closed: Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/29	# G/D	Dulling Beating the rivet was reduced wrong and had to be removed during removal the hole was enlarged.	Initial Chief Eng	Drill out all rivets on D 3560-041 Arm weldment. Clean all on all magnabond. QC inspect condition of Arm and Step.	1/2 08-01-29 1/2 08-01-29 1/2 08-01-29	✓ 08-01-29	Initial Chief Eng	S 06/01/29
		PC. Human Error.	Initial Chief Eng	Fill in the affected holes on Step and Arm weldment w/ H weld as per QSZ-004 Re Drill holes in correct location to ϕ . 128" in dia. Replace rivets 3106375 16 places	1/2 08-01-29 1/2 08-01-29	✓ 08-01-29	Initial Chief Eng	S 06/01/29
						!		S 06/01/29

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Job Number: 37029		Part Number: D3562042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	LARGE FAB 1	LARGE-FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod <u>M105058</u>		
2-Grind end cap welds flush as per Dwg D3562		
13.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
14.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
15.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
16.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3562 and QSI 005 4.4 Batch: <u>M106894</u>		
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
18.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Assembly Kit		

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37029		Part Number: D3562042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
19.0	QC21	FINAL INSPECTION/W/O RELEASE
		 (1)
Comment: FINAL INSPECTION/W/O RELEASE		2008/02/07

Job Completion



u 08.02.04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

